

Work Order ID 127828

127828

Page 1

Item ID: D206-802-022

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crew Door Opener RH 206A/B

Stop

NS2

Start Date: 12/10/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-12-23

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-2	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-802-022 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

1x

DAS
46
9-89

APR 23 2015

DAS
27
9-89

APR 17 2015

DAS
27
9-89

1x

DAS
46
9-89

APR 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127828***127828***

Page 2

Item ID: D206-802-022

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crew Door Opener RH 206A/B

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NS2

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Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPDD206-802-022

Location: 021

PPP rev: _____

(Lx)

DAS

46~~9-00~~

APR 23 2015

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 1504-27

MLJ 1504-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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December-17-14 1:56:23 PM

127828

D206-802-022

Required Date: 12/17/14

Required Qty: 1.00

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-15 *D3552-15* Door Prop	DAS 46 9-89	Manufactured	No			105	Each	7.0000	1	1		DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		APR 17 2015	
				ST363				7					
				821617				4					
				88100				3					
D3622-5 *D3622-5* Ball Stud	DAS 46 9-89	Manufactured	No			105	Each	30.0000	2	2		DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		APR 17 2015	
				ST052				30					
				104978				30					
D4110-2 *D4110-2* Door Doubler, RH	DAS 46 9-89	Manufactured	No			105	Each	7.0000	1	1		DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		APR 17 2015	
				ST091				7					
				85045				7					
D4110-3 *D4110-3* Doubler, Sill	DAS 46 9-89	Manufactured	No			105	Each	3.0000	1	1		DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		APR 17 2015	
				ST091				3					
				121635				3					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:56:23 PM

Page 2

Work Order ID: 127828

Parent Item: D206-802-022

Parent Item Name: Crew Door Opener RH 206A/B

127828

D206-802-022

Start Date: 12/10/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

CR3242-4-2

Purchased

No

105

Each

40.0000

5

5

CR3242-4-2

DAS

46

RIVET

9-89

**

DAS
27
9-89
APR 17 2015



Location

Loc Qty

Loc Code

ST317

40

m128813

40

m131340

5

MS20426AD4-5

Purchased

No

105

Each

2,806.000

4

4

MS20426AD4-5

DAS

46

RIVET

9-89

**

DAS
27
9-89
APR 17 2015



Location

Loc Qty

Loc Code

GA

110

m125807

110

ST312

2696

m125807

311

m130922

2385

4

MS20600-AD4W2

Purchased

No

105

Each

1,203.000

13

13

MS20600-AD4W2

DAS

46

Rivet

9-89

**

DAS
27
9-89
APR 17 2015



Location

Loc Qty

Loc Code

CCK004

889

m126475

889

GA

314

m125708

314

13

MS21073L5

Purchased

No

105

Each

12.0000

2

2

MS21073L5

DAS

46

Anchor Nut

9-89

**

DAS
27
9-89
APR 17 2015



Location

Loc Qty

Loc Code

ST300

12

m130799

12

m13187

2

December-17-14 1:56:23 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:56:23 PM

Page 3

Work Order ID: 127828

Parent Item: D206-802-022

Parent Item Name: Crew Door Opener RH 206A/B

127828

D206-802-022

Start Date: 12/10/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0532R

Purchased

No

105

Each

327.0000

6

6

NAS1149C0532R

DAS 46

WASHER

9-89

**

DAS

27

9-89

Location

Loc Qty

Loc Code

GA

62

116513

62

ST271

265

m128537

265

NAS1149C0563R

Purchased

No

105

Each

446.0000

6

6

NAS1149C0563R

DAS 46

Washer

9-89

**

DAS

27

9-89

Location

Loc Qty

Loc Code

ST271

446

m125928

46

m131026

400

MS27130-A26

Purchased

No

105

Each

56.0000

1

1

MS27130-A26

DAS 46

Rivnut

9-89

**

DAS

27

9-89

Location

Loc Qty

Loc Code

ST279

56

116521

56

APR 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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REFERENCE ONLY

APR 20 2015

DAS
46
9-20

DART AEROSPACE LTD.

ICA-D407-802

Page 27 of 31

52.4.5 D206-802-021/-022 Crew Door Opener Kits

Qty -021	Qty -022	Part Number	Description
		D206-802-021	CREW DOOR OPENER KIT, LH
		D206-802-022	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
2	2	D3622-5	BALL STUD
1		D4110-1	DOOR DOUBLER
	1	D4110-2	DOOR DOUBLER
1	1	D4110-3	DOUBLER, SILL
5	5	CR3242-4-2	RIVET
4	4	MS20426AD4-5	RIVET
13	13	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT (OR A10-130)
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

52.4.6 D206-802-023/-025 High Vis Crew Door Opener Kits

Qty -023	Qty -025	Part Number	Description
		D206-802-023	HIGH VIS CREW DOOR OPENER KIT, LH OR RH
		D206-802-025	HIGH VIS CREW DOOR OPENER RETROFIT KIT
1	1	D3552-17	DOOR PROP
2	2	D3622-7	BALL STUD
1		D4110-3	DOUBLER, SILL
1	1	D4111-3	SILL FITTING
2	2	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
13		MS20600AD4W2	RIVET
1		MS21073L5	ANCHOR NUT
1	1	MS27039C5-11	SCREW
1		MS27130-A26	RIVNUT (OR A10-130)
2	2	NAS1149C0563R	WASHER

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52-00-00

Revision: 0